

# Work Order ID 81379

**\*81379\***

Wednesday, March 14, 2012 10:29:15 AM

*April 2nd* Page 1

Item ID: D3914-041      Accept      **\*N900040100\***      Setup Start **\*NS1\***  
 Revision ID:      Stop **\*NS2\***  
 Item Name: Long Basket Lid Assembly (350)  
 Start Date: 3/14/2012      Start Qty: 1.00      **\*1\***      Cust Item ID:  
 Required Date: 3/30/2012      Req'd Qty: 1.00      **\*1\***      Customer:  
 Reference:

Approvals:      Process Plan: *MF*      Date: *12-03-14*      Tooling:      Date:      Run Start **\*NR1\***  
 QC:      Date:      SPC (Y/N):      Date:      Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
<b>Draw Nbr</b>	<b>Revision Nbr</b>								
D3914	B								
D4020	A								

100 Weld per dwg A/R S.S. rod Batch: *M/15778* 0.00  
 Large Fab

**\*100\***

Large Fab

Large Fab

Memo

0.00

1- assemble ribs , weld as per dwg D3914 using DT9607A

2- weld hinge (3) and Mounting brackets as per dwg D3914

\*\*\*Visual inspect before welding mesh\*\*\*

3- tack weld mesh on basket as per dwg D3914

\*\*\*Cut out mesh where label plate goes in center off basket lid as per dwg D4020-5. Make sure to place mesh correctly on lid, check with label plate before tacking mesh\*\*\*

*12.03.26 1x*

110

QC9- Inspect visual per QSI004- Fusion Welds 0.00

**\*110\***

QC

Quality Control

Memo

0.00

*12.03.27*

*1x*

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 <b>*120*</b> QC Quality Control	QC6- Inspect dimensions to drawing  Memo	0.00  0.00							
				5/2/03/07					
130 <b>*130*</b> Powdercoat Powder Coating	Black Sandtex(Ref:4.3.5.7) per QSI005 4.3  Memo *** mask sides of hinge prior to powdercoat*** Start Time: 1h 00 Oven Temperature: 320°F Finish Time: 1h30	0.00  0.00							
				m 117 338					
140 <b>*140*</b> HandFinish Hand Finishing	Wing Walk as per dwg QSI005 4.4 Batch 120959  Memo 1- Mask data plate and apply wing walk on outside surface of mesh as per dwg 2- Install placard and label as per dwg ***Mask label plate to size of label, use scotchbrite red pad to lightly sand area for label, apply label ***	0.00  0.00							

1      Q      (DP)      12/03/27

1      BL      12.3.27

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Reference:

Approvals:      Process Plan:      Date:      Tooling:      Date:      Run Start **\*NR1\***  
QC:      Date:      SPC (Y/N):      Date:      Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	QC3- Inspect Part Finish	0.00							
<b>*150*</b>									
QC	Memo	0.00							
Quality Control									
160	Identify as per dwg & Stock Location: <b>D4030-041</b>	0.00							
<b>*160*</b>									
Packaging	Memo	0.00							
Packaging									
170	QC21- Final Inspection - Work Order Release	0.00							
<b>*170*</b>									
QC	Memo	0.00							
Quality Control									

81372

1 6 12 10 3/26

1 12 12 3-08

12/3/29

12-03-25

W/O:		WORK ORDER CHANGES					
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**NOTE:** Date & initial all entries

# Picklist Print

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Page 1  
*2*

Work Order ID: 81379

Parent Item: D3914-041

Parent Item Name: Long Basket Lid Assembly (350)

Start Date: 3/14/2012

Required Date: 3/30/2012

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A new issue DD 10.03.19 verified by:EC  
10.08.18 verified by:EC

IPP Rev:B as per dwg revB DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
✓ D2581 Mounting Bracket		Manufactured	No			100	Each	29.0000	2	<i>2</i>		<i>12.03.23</i>	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				WA005		29							
				69739		1							
				70766		2							
				77045		1							
				77523		25			<i>2x</i>				
✓ D3914-1 Rib		Manufactured	No			100	Each	0.0000	2	<i>2</i>		<i>B81407 → 2x 12.03.23</i>	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				WA		2							
				WA006		-2							
✓ D3914-7 Rib		Manufactured	No			100	Each	2.0000	2	<i>2</i>		<i>B81208 → 2x 12.03.23</i>	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				WA006		2							
				80164		2							
✓ D4016-3 Hinge Half, Lid		Manufactured	No			100	Each	18.0000	3	<i>3</i>		<i>12.03.23</i>	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				WA005		18							
				78495		18			<i>3x</i>				
✓ D4018-5 Rib		Manufactured	No			100	Each	7.0000	9	<i>9</i>		<i>B78041 → 9x 12.03.23</i>	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				WA005		7							
				80597		7							

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Page 2

Work Order ID: 81379

Parent Item: D3914-041

Parent Item Name: Long Basket Lid Assembly (350)

Start Date: 3/14/2012

Required Date: 3/30/2012

Start Qty: 1.00

Required Qty: 1.00

✓ D4020-5 Manufactured No 100 Each 1.0000  
Mesh (350 Basket Long, Lid)

Location	Loc Qty	Loc Code
WA	1	
78698	1	

B81180 → 1x 12.03.23

\* D4021-3 Manufactured No 100 Each 3.0000  
Data Plate

Location	Loc Qty	Loc Code
WA005	3	
75460	3	

12.03.26  
B81182 → 1x

✓ D4035-041 Manufactured No 100 Each 3.0000  
Lid Rib Assembly, Fwd (350 Basket)

Location	Loc Qty	Loc Code
WA006	3	
74642	3	

B81704 → 1x 12.03.23

✓ D4035-043 Manufactured No 100 Each 1.0000  
Lid Rib Assembly, Aft (350 Basket)

Location	Loc Qty	Loc Code
WA006	1	
76545	1	

B81201 → 1x 12.03.23

✓ D2728-3 Manufactured No 140 Each 0.0000  
Dart Logo label

15050.

1 1 12.3.27.

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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ITEM	QTY	P/N	DESCRIPTION
	X	D3914-041	LONG BASKET LID ASSY (350)
1	1	D3914-101	TUBULAR ASSY, LONG LID
2	2	D2581	MOUNTING BRACKET
3	1	D2728-3	DART LOGO LABEL
4	3	D4016-3	HINGE HALF, LID
6	1	D4020-5	LID MESH, 350 LONG BASKET
7	1	D4021-3	DATA PLATE

**D3914-041 LONG BASKET LID ASSY (350)**  
(MESH SHOWN LOCALLY FOR CLARITY)

**RELEASED**  
10.08.17  
ECN 10-596

B	REMOVED D4086-210, UPDATED DETAIL F ACCORDINGLY (A3-2). REASON: NOW INSTALLED BY OPERATORS PER D350-607-2 REV. C AND D350-607-3 REV. A.	MB	10.08.05
A	NEW ISSUE	JPH	10.03.16
REV.	DESCRIPTION	BY	DATE
DESIGN	AS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	SC	DRAWING NO.	REV. B
CHECKED	DA	D3914	SHEET 1 OF 4
MFG. APPR.	MB	TITLE	SCALE
APPROVED	MB	LONG BASKET LID ASSY (350)	NTS
DE APPR.	MB	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR EQUIPED OR EQUIPMENT TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
DATE	10.08.05		

# 81379

# Dart Aerospace Ltd

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**Dart Aerospace Ltd**

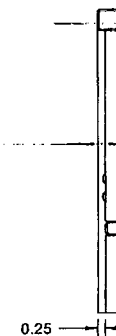
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**Part No:** \_\_\_\_\_ **PAR #:** \_\_\_\_\_ **Fault Category:** \_\_\_\_\_ **NCR:** Yes No **DQA:** \_\_\_\_\_ **Date:** \_\_\_\_\_  
**Resolution:** \_\_\_\_\_ **Disposition:** \_\_\_\_\_ **QA: N/C Closed:** \_\_\_\_\_ **Date:** \_\_\_\_\_

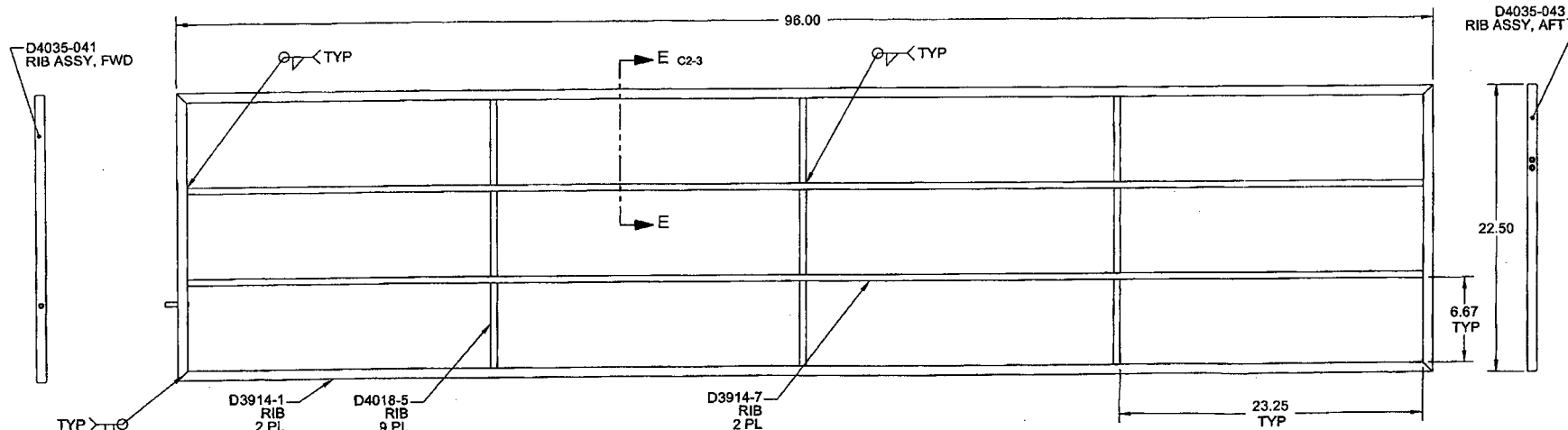
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ITEM	QTY -101	P/N	DESCRIPTION
	X	D3914-101	TUBULAR ASSY, LONG LID (350)
1	2	D3914-1	RIB
2	2	D3914-7	RIB
3	9	D4018-5	RIB
4	1	D4035-041	BASKET LID RIB ASSY, FWD
5	1	D4035-043	BASKET LID RIB ASSY, AFT



SECTION E-E C5-3



8 D3914-101 TUBULAR ASSY, LONG LID

RELEASED  
10.08.12

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 14.10 lbs
- 8) TOLERANCE FOR XX.XX DIMENSIONS  $\pm 0.06$  FOR D4018-101
- 9) WELD PER DART QSI 004

#81379

DESIGN	ALS	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3914	SHEET 3 OF 4
APPROVED		TITLE	SCALE
DE APPR.		LONG BASKET LID ASSY (350)	NTS
DATE	10.08.05	COPYRIGHT © 2010 BY DART AEROSPACE LTD	
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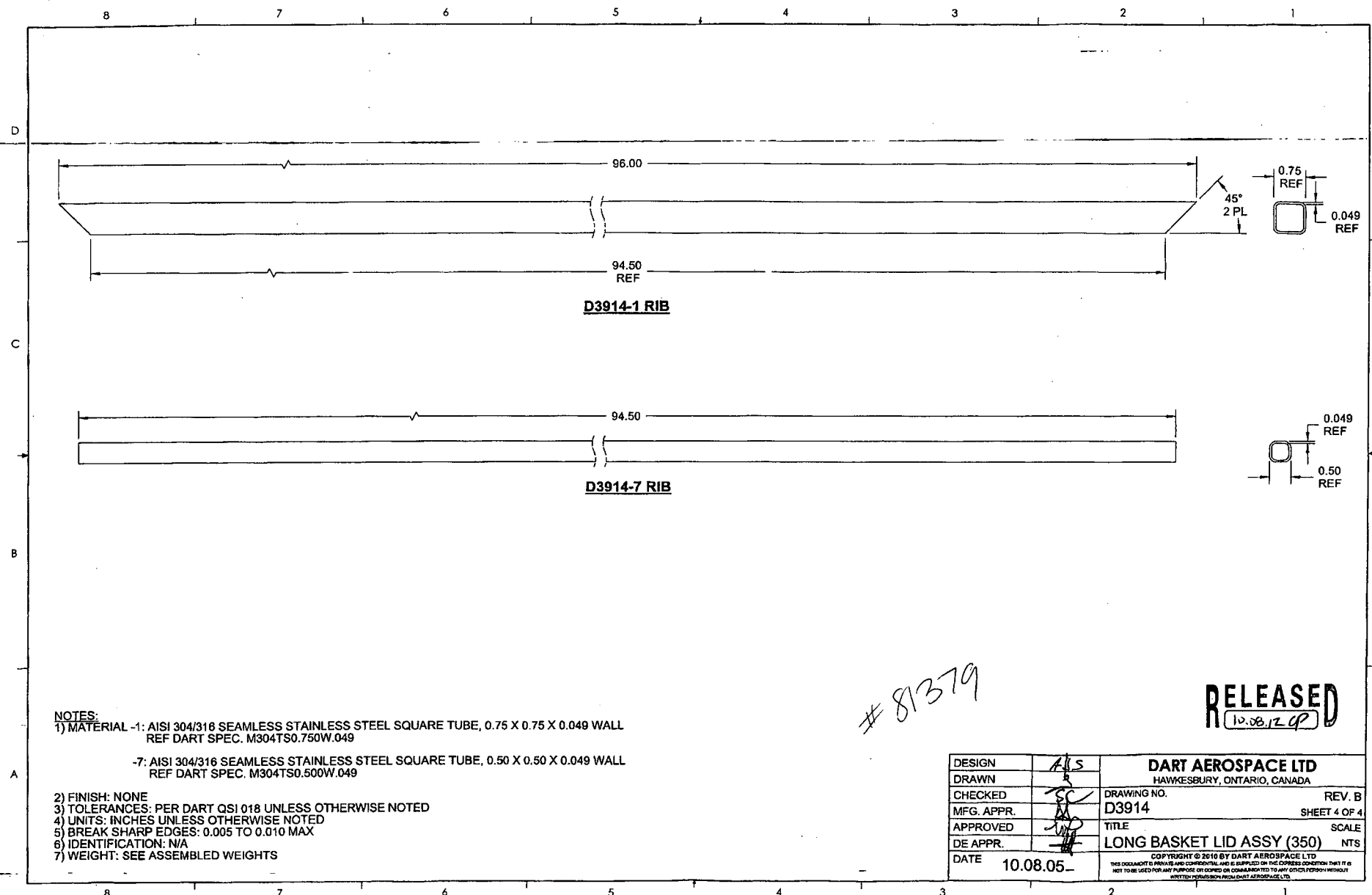
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RELEASED  
10.08.12 CP

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